

Date: Thursday, 3/8/2007 12:38:44 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	CROSSBOLT SPACER
Job Number	31112		
Estimate Number	11010		
P.O. Number	N/A	Part Number	D2649
This Issue	3/8/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D2649 REV B1
First Issue	N/A	Project Number	N/A
Previous Run	29329	Drawing Revision	B1
Written By		Material	N/A
Checked & Approved By		Due Date	4/5/2007
Comment	Est F 02/03/26	Qty:	600
	Added turning on Cobra NG	Um:	Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M6061T6T0375W058	6061-T6 Tube .375 x.058W 
		Comment: Qty.: 0.2975 f(s)/Unit Total : 178.4790 f(s) 6061-T6 Tube .375 x.058W Material: 6061-T6 or 5052-H32, 0.375" Dia X 0.058" Wall Batch: M18750 8'5" N102646 18' 4103145 x 48' 8.5 07/03/11
2.0	HARDINGE	HARDINGE CNC LATHE SMALL 
		Comment: HARDINGE CNC LATHE SMALL Machine as per folio FA 214 on cobra machine. 8.5 07/03/11
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE 3.4 07/03/11
4.0	QC8	SECOND CHECK 
		Comment: SECOND CHECK 5.0 07/03/11 X337
5.0	PACKAGING 1	PACKAGING RESOURCE #1 
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 0 C 07/3/12 337
6.0	QC21	FINAL INSPECTION/W/O RELEASE 
		Comment: FINAL INSPECTION/W/O RELEASE 3.0 07/03/13
	Job Completion	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 01/03/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31112
Description: Crossbolt Spacer	Part Number:	D2649
Inspection Dwg: D2649      Rev: B1		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

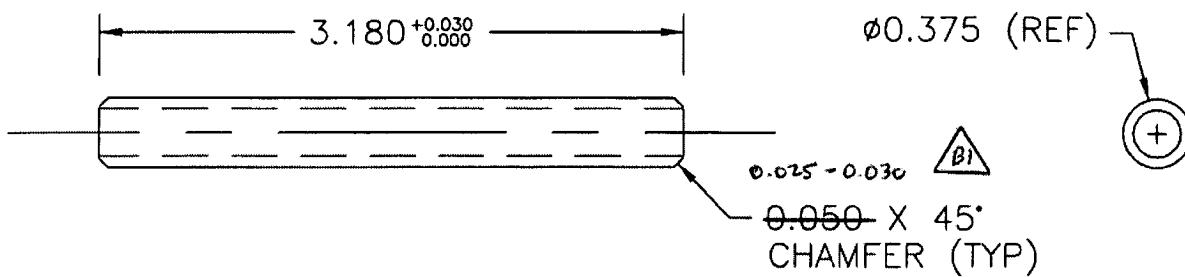
## X First Article      Prototype

Measured by:	J.W.	Audited by:	S.D.	Prototype Approval:	N/A
Date:	07/03/11	Date:	07.03.11	Date:	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	04.01.21	New Issue	KJ/RF	TT

**DART**

DESIGN <i>DMY</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DMY</i>	APPROVED <i>BW</i>	DRAWING NO. D2649	REV. B SHEET 1 OF 1
DATE 98.01.14		TITLE CROSS BOLT SPACER	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	98.01.14	3.180 WAS 3.230, ADD CHAMFER	
B1	<del># CP</del> 02.06.13	REDUCE CHAMFER PER TSR 1206.	

**RELEASED**  
98.01.20 DS


MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)

0.375 DIA 0.058 WALL

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
31112